

### **Amendments to the Claims**

This listing of claims will replace all prior versions, and listings, of claims in the application:

#### **Listing of Claims:**

1. (Currently Amended) A process for shaping and processing pipes, with a plurality of adjustable bending units comprising the following steps:
  - a) moving the plurality of bending units freely along ~~the pipes~~ at least one pipe; and
  - b) performing a plurality of simultaneous bending operations using the adjustable bending units.
2. (Currently Amended) The process according to claim 1, further comprising the steps of:
  - a) engaging two end sections of the ~~pipes~~ pipe using one of the plurality of bending units; and
  - b) applying at least one ~~additional~~ bending unit to the pipe with each of said at least one bending unit

corresponding to a respective one of a number of ~~further~~ bending operations ~~planned~~.

3. (Currently Amended) The process as in claim 1, wherein said plurality of bending units comprises outer bending units which move towards each other longitudinally and inner bending units wherein said inner bending units move apart from each other laterally.

4. (Currently Amended) The process as in claim 1, further comprising the steps of:

providing a plurality of profiled rollers; and

bending a ~~piece of material~~ section of the pipe using said plurality of profiled rollers.

5. (Currently Amended) The process as in claim 4, wherein said step of providing a plurality of profiled rollers includes providing profiled double rollers between a ~~piece of material~~ section of the pipe that requires bending.

6. (Currently Amended) The process as in claim 4, wherein said step of providing a plurality of profiled rollers includes

providing at least two outer bending units having gripping pliers.

7. (Original) The process as in claim 6, wherein said gripping pliers are profiled.

8. (Currently Amended) The process as in claim 1, further comprising the step of:

pressing a plurality of sealing nipples axially into two end sections of a piece of pipe shaped material that are being held by said bending units ~~or said gripping pliers~~.

9. (Currently Amended) The process as in claim 8 wherein said step of pressing said sealing nipples into said end sections comprises expanding said end sections by about 45° degrees to create a flange.

10. (Currently Amended) The process as in claim 1, further comprising the step of heating said pipe ~~material~~ to bend said pipe ~~material~~.

11. (Original) The process as in claim 10, wherein said heating step is before said bending step.

12. (Original) The process as in claim 10, wherein said heating step is during said bending step.

13. (Original) The process as in claim 10, wherein said heating step is after said bending step.

14. (Original) The process as in claim 10, wherein said heating step includes heating the material into a thermoplastic range.

15. (Original) The process as in claim 10, wherein said heating step includes using a radiation heater.

16. (Original) The process as in claim 15, wherein said heating step includes using an infrared heater.

17. (Currently Amended) The process as in claim 10, wherein said heating step includes channeling steam through a pipe section to heat the material.

18. (Currently Amended) The process as in claim 10, wherein said heating step includes using hot air to heat up ~~the plastic a~~ pipe section.

19. (Original) The process as in claim 18, wherein said heating step includes pressurizing the hot air in the pipe section.

20. (Original) The process as in claim 19, wherein said hot air is left in said pipe section under pressure.

21. (Currently Amended) The process as in claim 20, further comprising the step of cooling the ~~piece of material~~ pipe section after the bending and heating operations have been completed.

22. (Original) The process as in claim 20, further comprising the step of forcing cold water through the pipe section for cooling purposes.

23. (Currently Amended) The process as in claim 1, further comprising the step of pressurizing ~~the~~ a pipe section internally during the bending operation.

24. (Currently Amended) The process as in claim 1, wherein ~~the~~ a cross section of ~~the~~ a pipe section is stabilized during the bending operation via an insertion of a flexible core.

Claims 25-38 withdrawn.